

Work Order ID 133436

Monday, June 08, 2015 4:09:37 PM

133436

Page 1

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gh Lug
 Start Date: 6/08/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/08/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 09 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3405	Rev B

100	FLOW WATER JET	0.00				14	Ø		Jm15-6-12
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1-Cut as per Dwg D3405								
304 .125"	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				14	Ø		Jm15-6-12
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(14)			
120									
QC	Memo	0.00							
Quality Control									

OAS
38
9-89
JUN 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Monday, June 08, 2015 4:09:37 PM

Page 2

MAL 15-07-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 133436

Monday, June 08, 2015 4:09:37 PM

133436

Page 3

Item ID: D3405-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gh Lug

Start Date: 6/08/15

Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/08/15

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

(14) 1507.29 DAS
9
9-89

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

(14) 1507.29 DAS
9
9-89

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

N113154 =

10:20 AM

300°C

11:20 AM

14 x 6 Jell 6/01/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

Picklist Print

Monday, June 08, 2015 4:09:37 PM

Page 1

Work Order ID: 133436

133436

Parent Item: D3405-043

D3405-043

Parent Item Name: Gh Lug

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A05.09.01New issueKJ/JLM

IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	59.0000	1	8			

D3404-1

GHW/ Lug

Location

Loc Qty

Loc Code

WA001

59

119001

x14

40

121116

19

M304S11GA

Purchased

No

150

sf

172.0257

0.154

M304S11GA

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

172.0257

122521

40.034

M128254

56

M129545

36.575

M129972

39.4167

x14

15-0728

MAL

(2)

Jm15-6-72

129972

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

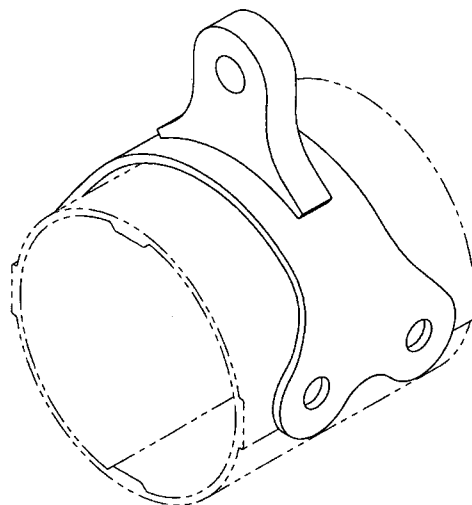
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Off-set ☐																																																																				
Mislabeled ☐																																																																				
Fit/Function ☐																																																																				
Misaligned/off center ☐																																																																				
Positioned Wrong ☐																																																																				
Outside Dimensions ☐																																																																				
Over/Under tolerance ☐																																																																				
Part Incorrect ☐																																																																				
Part Lost/Missing ☐																																																																				
Part Moved ☐																																																																				
Drawing ☐																																																																				
Finish ☐																																																																				
Misread ☐																																																																				
Turning Sequence ☐																																																																				
OTHER : _____																																																																				

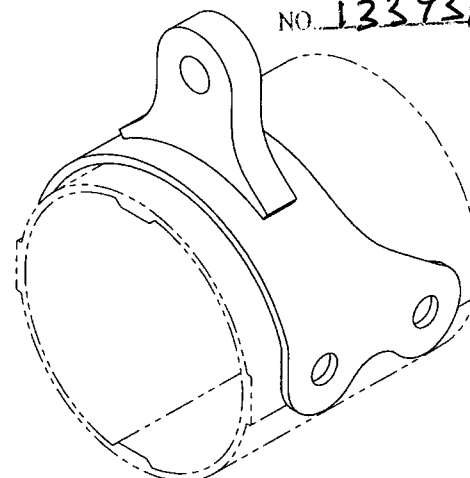
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B

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WORK ORDER
NO. 133936 MJS
1506-09



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



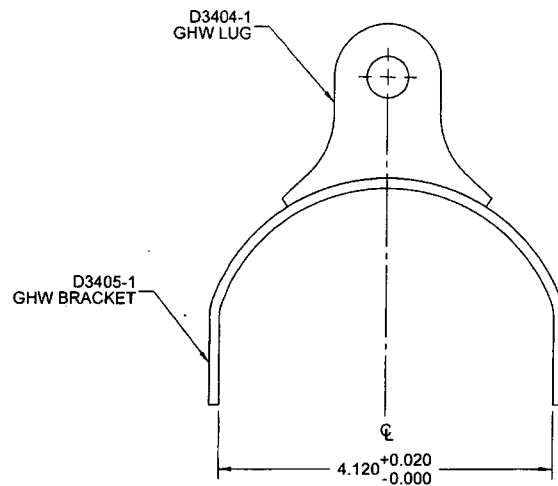
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

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08/12/18 MJS

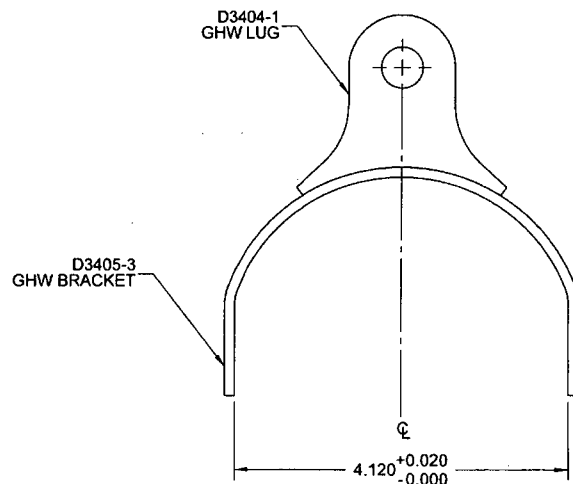
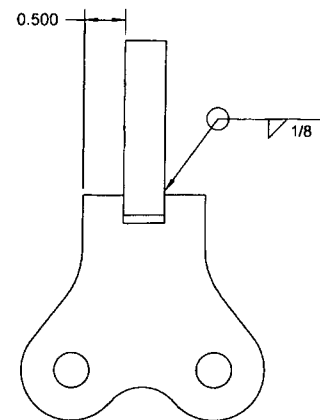
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

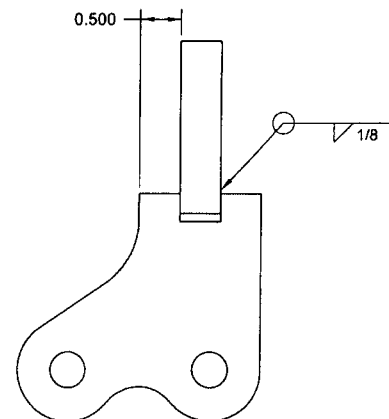
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL. (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3405-041 LUG ASSEMBLY

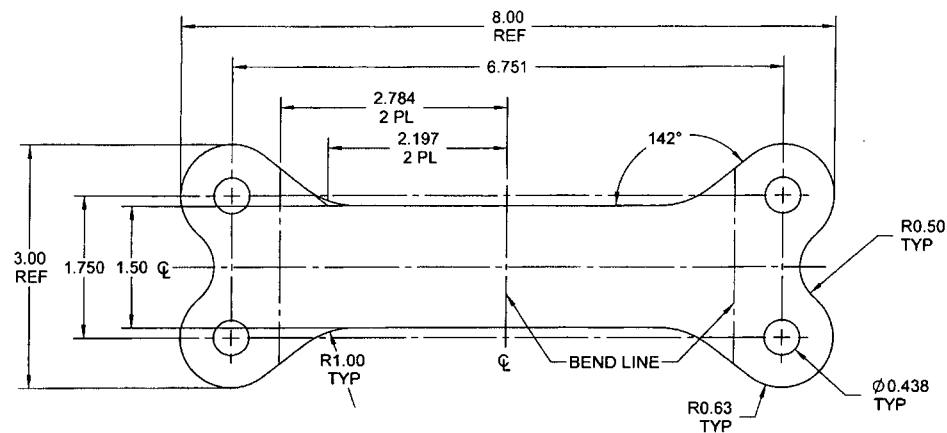


D3405-043 LUG ASSEMBLY

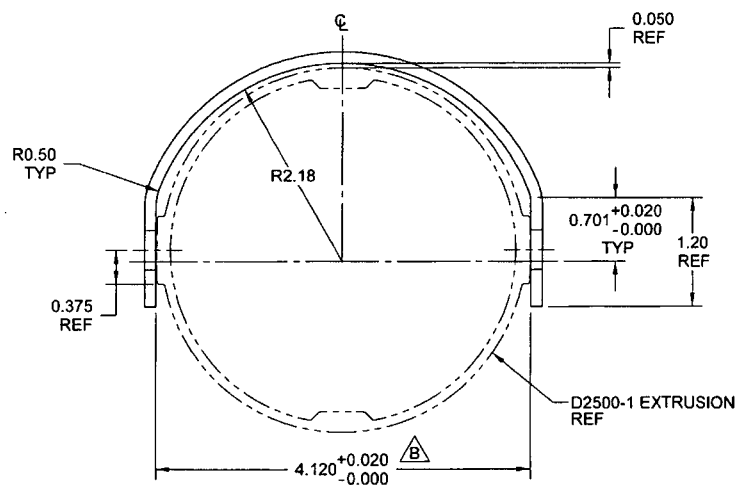


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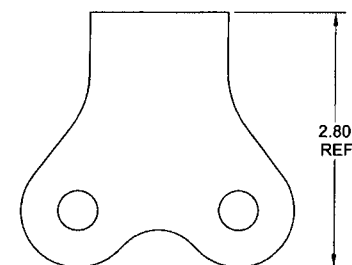
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 2 OF 4
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



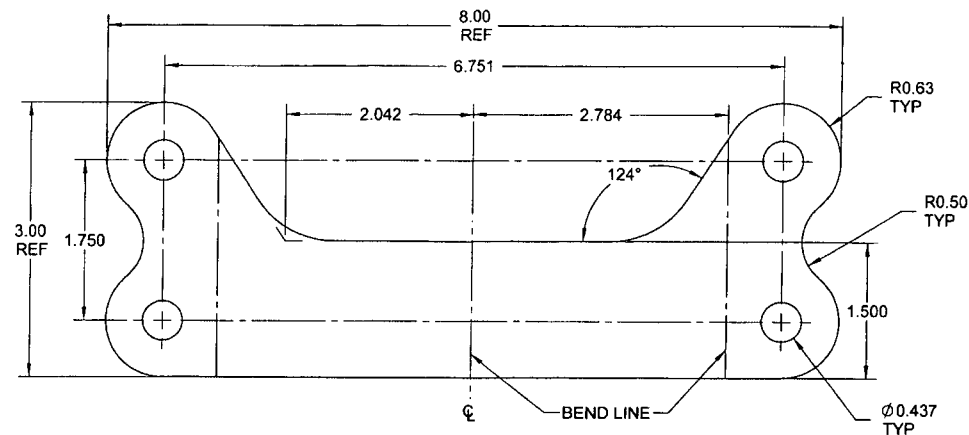
SIDE VIEW FOR REF ONLY

NOTES:

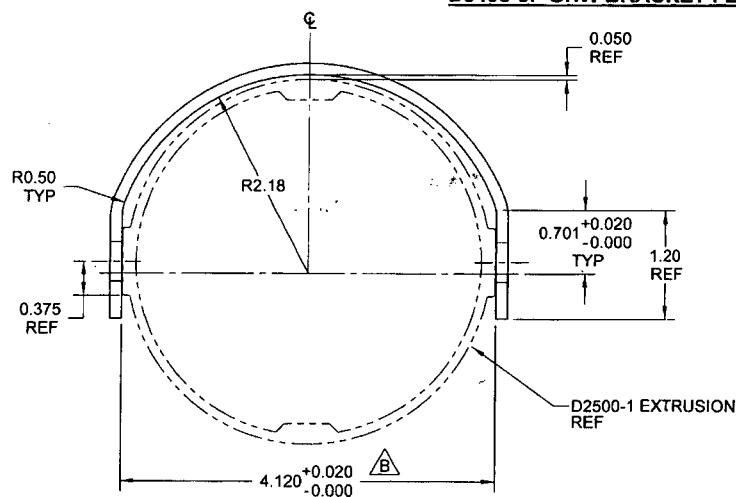
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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08/08/12/18

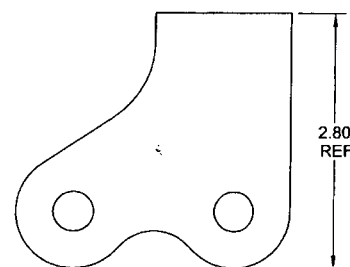
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

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08/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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